101975

Page 1

May-21-13 3:4	15:11 PM				. , , . ,						``
Item ID: Revision ID:	D4052-1			Accept	*N900	040	100)* s	Setup Sta	1/1	S1*
Item Name: Start Date: Required Date Reference:	Eye Bolt 5/21/13: 6/04/13	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item I Customer:	D:			Sto	*N	S2*
Approvals:	Process Pla	n:Mしブ	Date: 13-05-7	22 Tooling:	Da	ite:	_	R	tun Sta	^{rt} *N	R1*
	QC:		Date:	SPC (Y/N):	Da	ite:			Sto	*N	R2*
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr		· · ·					- 4-3		
D4052	Α										
100				0.00							
100 Doosan		Memo		0.00				1/	Ø		
Doosan Lathe		TURN AS P DWG REV: FOLIO REV DEBURR	ER FOLIO FA892 AND	DDWG N I I	-5-30						
110		QC2- Inspect parts off ma	achine FAI/FAIB	0.00							
110 QC Quality Control		Memo		0.00	13-5-	30			D		

										DQA:	Date:	
NCR: Ye	es / No				WORK ORDER NON-C	CON	FORN	AANCE / UPD	ATE		· · · · · ·	
										QA Closed:	Date:	
Work Order	֥				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
WOIK Older	·				Rework	1		Skid-tube	Crosstube		Water Jet	Engineering
Part No	0.				Scrap	1	ſ	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is	1	Therm	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR N	o				Work Order Update]		Large Fab	Composite		Supplier	
	·	 -	γ			ᆛ				C' 0		
Root		_			ption of work order update	1	itial	Actio		Sign &		061
Cause	Date	Step	Qty	(or Non-conformance	Chie	ef Eng	Descri	ption	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling _	_											
Operator												
Material	_					ŀ						
Setup	_											
Other										ļ		
Process				Į								
Supplier			· .									
Training						İ						
Unapproved		<u> </u>										
					F	AULT	CATE	GORY				
Landin	g Gear				General	_				•	-	•
	Bending				Bend	Ц°	Grain		<u></u>	Ovalized		Pressure/Forced
. [Centre N	ot Conce	ntric to	o/s	BOM/Route	L	Hardwa	re	<u> </u>	Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged		nspecti	on Incomplete		Part Incorre	:t <u></u>	Weld
Γ	Crushed/	Crimped			Burrs	U	nstruct	ions Incomplete/Ui	nclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination		Mainte	nance		Part Moved		
ľ	Heat Trea	at			Countersink		Mislabe	led		Positioned V	Vrong	
-	Inspectio	n Strip in	Tube		Cut Too Short		Misread	1		Power Loss/	Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

May-21-13 3:45:11 PM Item ID: D4052-1 Accept *N900040100* Setup Start **Revision ID:** Item Name: Eye Bolt Start Otv: 6.00 **Start Date:** 5/21/13 **Cust Item ID:** Required Date: 6/04/13 Reg'd Otv: 6.00 **Customer:** Reference: Run Process Plan: _____ Date: Approvals: Tooling: Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Plan Tool ID Tool# Reject Accept Reject Insp. Work Center ID Description Qty **Run Hours** Code **Qty** Number Stamp 120 QC8- Inspect parts - second check 0.00 *120* 113-05-31 0.00 Memo Quality Control Identify as per dwg & Stock Location: \$\)\[\times \) 0.00 130 *130* Packaging 0.00 Memo Packaging 140 QC21- Final Inspection - Work Order Release 0.00 *140* QC 0.00 Memo Quality Control

\$ 13-06-41

											DQA:	Date:	
NCR:	es /	No				WORK ORDER NON-C	CON	FORN	MANCE / UP	DATE			
						. "					QA Closed:	Date:	
Work Orde	a ji .					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part N						Rework Scrap Use-as-is		V	Skid-tube Machining oforming	Crosstube Small Fab Finishing	1	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR I	lo					Work Order Update			Large Fab	Composite	i Nec/3tol	Supplier	
Root					Descri	ption of work order update	ln	itial	Act	tion	Sign &		
Cause	D	ate	Step	Qty		or Non-conformance	Chie	f Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling													
Operator													
Material													
Setup													
Other						•							
Process				ļ			}						
Supplier							ł					*	
Training													-
Unapproved									-		i 		
						F/	AULT	CATE	GORY				
Landi	ng Gear					General							-
	Ber	ding				Bend		irain			Ovalized		Pressure/Forced
	Cer	tre No	t Conce	ntric to	o/s	BOM/Route	∐⊦	lardwai	re		Over/Under	tolerance	Temperature/Cure
	Cra	cks				Broken/Damaged		nspection	on Incomplete	<u></u>	Part Incorred	ct	Weld
	Cru	shed/0	Crimped			Burrs		nstructi	ons Incomplete/	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuf	fs				Contamination		⁄lainte	nance	`	Part Moved		
!	Hea	t Trea	t			Countersink		/lislabe	led		Positioned V	Vrong	_
	Ins	ection	n Strip in	Tube		Cut Too Short	\square	/lisread			Power Loss/	Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Drill Holes Drawing

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Picklist Print

May-21-13 3:45:15 PM

Work Order ID: 101975

D4052-1

Parent Item Name: Eye Bolt

101975 *D4052-1*

Start Date: 5/21/13

Required Date: 6/04/13

Page 1

Start Qty: 6.00

Required Qty: 6.00

Comments:

Parent Item:

IPP REV:A NEW ISSUE 10-01-07 JLM VERIFIED BY:DD

Rev:B as per dwg REV.A DD 10.02.22 verified by:EC

IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R0.750		Purchased	No			100	f	135.3200	0.1871	1.181684			· · · · · · · · · · · · · · · · · · ·
M303R0	750								**			13 -	7-7

303 Round Bar 0.750

Location Loc Qty Loc Code MAT028 50.653 123313 50.653 MAT029 84.667 125387 84.667

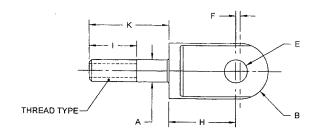
	DQA:	Date:	
RDER NON-CONFORMANCE / UPDATE			,

Work Order: DISPOSITION AGAINST DEPARTMENT/PROCESS	Other QC Inspector
Work Order: Rework Skid-tube Crosstube Water Jet English Skid-tube Skid-tube Trosstube Water Jet English Scrap Machining Small Fab Prod. English Coor. Use-as-is Thermoforming Finishing Rec/Store/Packaging	Quality Other
Part No Scrap Machining Small Fab Prod. Eng. Coor Use-as-is Thermoforming Finishing Rec/Store/Packaging	Quality Other
NCR No. Work Order Update Large Fab Composite Supplier Supplier	QC Inspector
	QC Inspector
Root Description of work order update Initial Action Sign &	QC Inspector
Cause Date Step Qty. or Non-conformance Chief Eng Description Date Verification C	
Doc/Data Equip/Tooling	
Operator Material Setup	
Other Process	
Supplier Training Unapproved	:
FAULT CATEGORY	
Landing Gear General	
Bending Bend Grain Ovalized Press	essure/Forced
	mperature/Cure
Cracks Broken/Damaged Inspection Incomplete Part Incorrect Weld	
	ong Stock Pulled
Heat Treat Countersink Mislabeled Positioned Wrong Inspection Strip in Tube Cut Too Short Misread Power Loss/Surge Othe	ner
Ripples in Bend Drill Holes Offset	ici
Torque Waves in Extrusion Drawing Out of Calibration	
Turning Sequence Finish Out of Sequence	
Wave/Twist in Tube Folio Outside Dimensions	

DART AEROSPACE LTD	Work Order:	101975
Description: Eyebolt	Part Number:	D4052-1
Inspection Dwg: D4052 Rev: A		Page 1 of 1

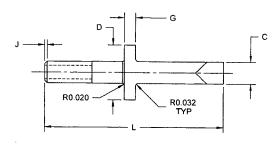
nspe	ection Dwg: D40	52 Rev : A			<u> </u>		Pa	ige 1 of 1
		FIRST AF	RTICLE INSP	PECTION	CHECK	KLIST		
	•	X	First Article		Prototy	pe .		
Draw	ving Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Co	mments
Α	Ø0.249	+0.000/-0.003	.2475					
В	R0.31	+/-0.030	R.30		,		·	
С	0.25	+/-0.030	-25/					
D	Ø0.63	+/-0.030	.629					
E	Ø0.257	+0.005/-0.001	.257				V	
F	0.050	+/-0.010	-01C					
G	0.125	+/-0.010	-:/2ア					
Н	0.75	+/-0.030	. 250					*
ı	0.531	+/-0.010	.540					
J ·	0.03 x 45°	+/-0.030 x 0.5°	.03x45°					
K	0.89	+/-0.030	.851				**************************************	
L	2.01	+/-0.030	2.0/2			·		
1/-	4-28 UNF-3A	N/A		/				
	MOW	Max: 0.2678 Min: 0.2653	-266	~				
	MATERIAL TO THE PARTY OF THE PA							
			:					
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	. '							
		,						
leas	ured by:	Auc	lited by:		Pro	totype Approva	al:	N/A
	Date: 13-5	-28		-05-30		Dat	:e:	N/A
Rev	Date Char					Revised	d by	Арргоуе
A		Issue			······································	Revises	X	<i>771</i>

	Date:	3-5-25	Date:	13-05-30			Date):	N/.	A	
Rev	Date	Change	· · · · · · · · · · · · · · · · · · ·			Rev	ised	by	App	roved	
Α	10.04.01	New Issue			 	 KJ					
							7		1		





C



SER K FM2 UNCONT: SUBJECT T WHER

NO 101975 MLS

D4052-X EYE BOLT

13-05-22

P/N	THREAD TYPE	Α	В	С	D	E	F	G	Н			K	
D4052-1	1/4-28 UNF-3A	Ø0.249 +0.000	R0.31	0.25	Ø0.63	Ø0.257	0.050	0.125	0.75	0.531	0.03	0.89	2.01
													<u> </u>
													├

DELEASE 1 2010 -02- 16

NOTES: 1) MATERIAL: AISI 303 STAINLESS STEEL, ROUND BAR PER DART SPEC M303R

PER DART SPEC M303R
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.06 lbs

A NEW ISSUE RF 10.01.28 REV. DESCRIPTION BY DATE DESIGN RF DART AEROSPACE LTD DRAWN RF HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. A D4052 MFG. APPR. SHEET 1 OF 1 APPROVED TITLE SCALE EYE BOLT DE APPR. NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD
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